

Date: Thursday, 22/01/2009 8:27:31 AM
 User: Linda Lacelle

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	BRACKET ASSEMBLY
Job Number :	45060		
Estimate Number :	10771		
P.O. Number :		Part Number :	D3462042
This Issue :	22/01/2009	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	D3462 REV C
First Issue :	/ /	Project Number :	N/A
Previous Run :	44487	Drawing Revision :	C
	Type :	Material :	
	LARGE FAB ASSY	Due Date :	29/01/2009
Written By :		Qty:	5/6 Um: Each
Checked & Approved By :			
Comment :	EST REV. A 05.11.18 NEW ISSUE EC esr rev B 08.07.15 ecn 1049 EC verified by: DD		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D34621	BRACKET ASSEMBLY
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

Base Flat Pattern

Pick:

Qty	Part Number	Description	Batch
1	D3462-1	Base Flat Pattern	B45017

EL 9-1-22 x5

2.0	D34623	Lug
-----	--------	-----



Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

Flange

Pick:

Qty	Part Number	Description	Batch
1	D3462-3	flange	B37790

EL 9-1-22 x5

3.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
-----	-------------	------------------------------



Comment: LARGE FABRICATION RESOURCE 1

Weld assembly as per dwg D3462

EL 9-1-22 x5

4.0	QC9	VISUAL WELDING INSPECTION
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Comment: VISUAL WELDING INSPECTION

H 09/01/23

5.0	QC5	INSPECT WORK TO CURRENT STEP
-----	-----	------------------------------



Comment: INSPECT WORK TO CURRENT STEP

09-01-23
 (5)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET ASSEMBLY

Job Number: 45060

Part Number: D3462042

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

POWDER COATING

POWDER COATING



m109996



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.2) as per QSI 005 4.3

START TIME:

1:25

OVEN TEMPERATURE:

400°

FINISH TIME:

1:55

FL 09/01/26

(5)

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



gld



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

09-01-26

(25)

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 464

9/1/27

(5x)

sp

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/01/28 HJ

Job Completion



u 9.01.27

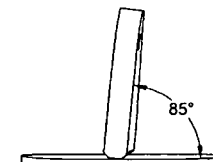
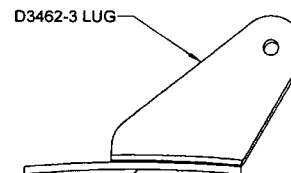
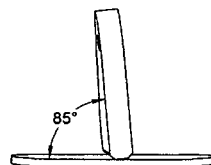
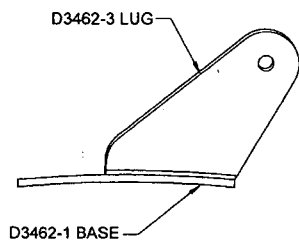
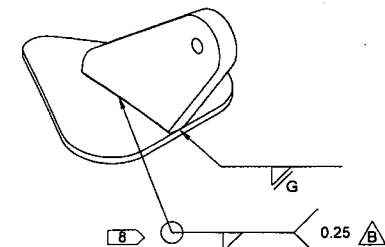
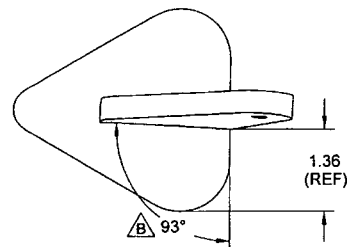
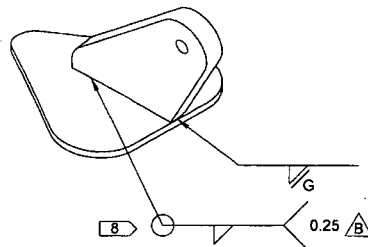
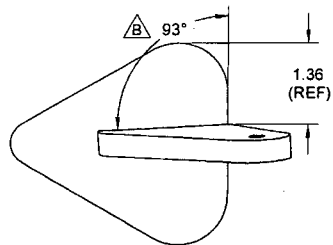
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NOTE: Date & initial all entries



D3462-041 BRACKET ASSEMBLY

D3462-042 BRACKET ASSEMBLY

QTY	QTY	P/N	DESCRIPTION
X	-041	D3462-041	BRACKET ASSEMBLY
X	-042	D3462-042	BRACKET ASSEMBLY
1	1	D3462-1	BASE
1	1	D3462-3	LUG

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3462-041" OR "D3462-042" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.75 lbs (TYP)
- 8) WELDING: PER DART QSI 004

C	SHOW VIEWS OF D3462-041 & D3462-042, UPDATE DWG	DC	07.10.24
B	REVISE DIMENSIONS	RF	05.12.05
A	NEW ISSUE	RF	05.09.20
REV.	DESCRIPTION	BY	DATE
DESIGN	DESIGN	DART AEROSPACE LTD	
DRAWN	DRAWN	HAWKESBURY, ONTARIO, CANADA	
CHECKED	CHECKED	DRAWING NO.	REV. C
MFG. APPR.	MFG. APPR.	D3462	SHEET 1 OF 2
APPROVED	APPROVED	TITLE	SCALE
DE APPR.	DE APPR.	BRACKET ASSEMBLY	1:2
DATE	07.10.24	COPYRIGHT © 2005 BY DART AEROSPACE LTD	
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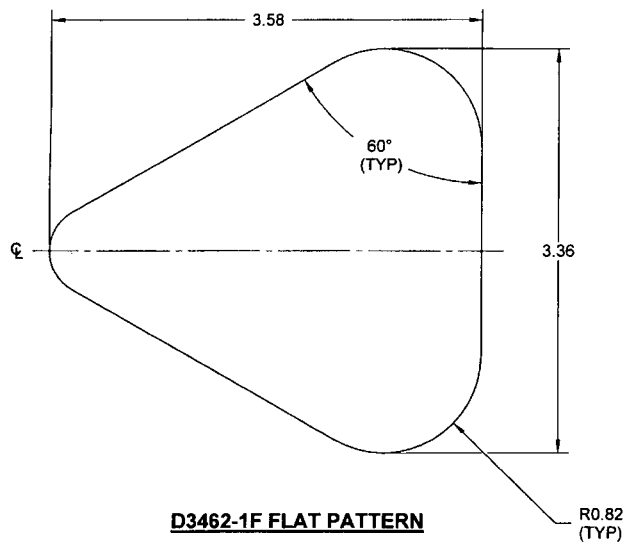
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

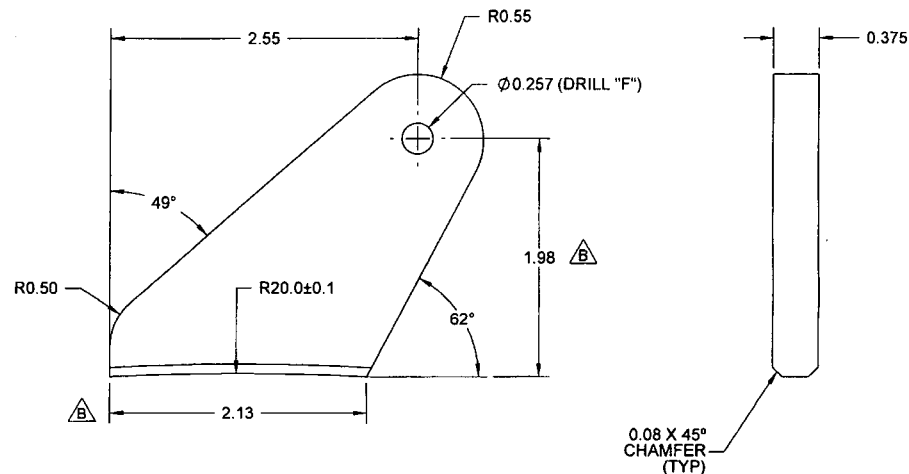
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



- NOTES:**
- 1) MATERIAL: AISI 304 SS SHEET, 0.125 THICK
PER MIL-S-5019 (ANNEALED), 2B FINISH
(REF. DART SPEC. M304S11GA)
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 0.28 lbs



- NOTES:**
- 1) MATERIAL: AISI 304 SS BAR
(REF. DART SPEC M304B0.375X03.000)
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 0.47 lbs

RELEASED
8-07-07

DESIGN	1F	DART AEROSPACE LTD	
DRAWN	1/20/02	HAWKESBURY, ONTARIO, CANADA	
CHECKED	1/20/02	DRAWING NO.	REV. C
MFG. APPR.	1/20/02	D3462	SHEET 2 OF 2
APPROVED	1/20/02	TITLE	SCALE
DE APPR.	1/20/02	BRACKET ASSEMBLY	
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